

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012080**Date Inspected:** 08-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wuzhi Chang, Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder(OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Segment#7BW-PP52

This QA inspector observed, ZPMC qualified welding personnel identified as 068917 perform Shielded Metal Arc Welding (SMAW); weld joint identified as SEG035-044, ZPMC CWI is identified as Mr.Li Yang
The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-TC-U4b-FCM-1,

Segment#7BW-PP52

This QA inspector observed, ZPMC qualified welding personnel identified as 066673 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW7B-009; ZPMC CWI is identified as Mr.Li Yang The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T. See the attached Photo.

Segment#6CW-PP47

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

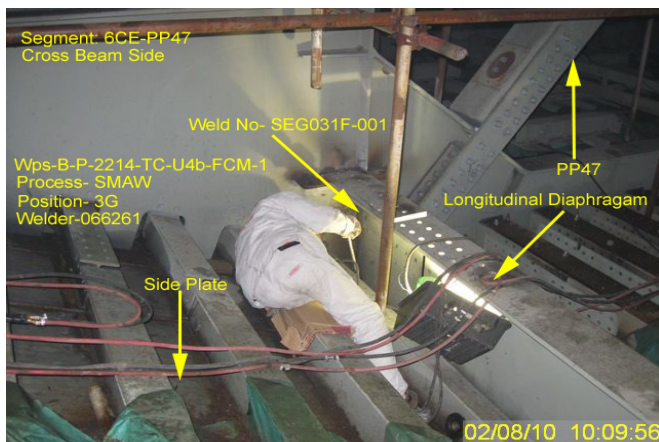
This QA inspector observed, ZPMC qualified welding personnel identified as 066261 perform Shielded Metal Arc Welding (SMAW); weld joint identified as SEG031F-001, ZPMC CWI is identified as M. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2214-TC-U4b-FCM-1, See the attached Photo.

This QA inspector observed, ZPMC qualified welding personnel identified as 066673 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW7B-009; ZPMC CWI is identified as Mr. Li Yang. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233T

This QA inspector observed, ZPMC qualified welding personnel identified as 045143 perform Flux Core Arc Welding (FCAW), weld joint identified as OBW7B-008; ZPMC QC is identified as Mr. Feng Ya Jun. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2231T

Segment#CB6-PP45

This QA inspector observed, ZPMC qualified welding personnel identified as 066002 perform Shielded Metal Arc Welding (SMAW); weld joint identified as SSD-PP45-185, ZPMC CWI is identified as Mr. Wu Zhi Cheng. The welding parameters measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2212-TC-U4b-FCM-1,



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 15000422372, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By: Prabhune,Manoj

Quality Assurance Inspector

Reviewed By: Miller,Mark

QA Reviewer